

Date: Tuesday, 8/14/2007 6:32:10 AM
 User: Jean-Luc Menard

Process Sheet

Customer : CU-DAR001 Dart Helicopters Services	Drawing Name : LEVER
Job Number : 33887	
Estimate Number : 10585	
P.O. Number : <u>N/A</u>	Part Number : D2160
This Issue : 8/14/2007 S.O. No. : <u>N/A</u>	Drawing Number : D2160 REV B
Prsht Rev. : NC	Project Number : N/A
First Issue : <u>N/A</u> Type : SMALL /MED FAB	Drawing Revision : B
Previous Run : 28386	Material : <u>N/A</u>
Written By : <u>JLM/07-08-14</u>	Due Date : 8/21/2007
Checked & Approved By : <u>JLM/07-08-14</u>	Qty: 50 Um: Each
Comment : Est. C 04.11.04 Reformat KJ/RF	
Est Rev:D Now on Waterjet 06-09-06 JLM	

Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :
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1.0	M304S14GA	304SS .080
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Comment: Qty.: 0.0182 sf(s)/Unit Total : 0.9083 sf(s)

304SS .080

(M304S14GA)

BATCH: M105112 HB 07-08-14

2.0	WATER JET	FLOW WATER JET
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Comment: FLOW WATER JET

1-Cut as per Dwg D2160

Dwg Rev: BProg Rev: BHB 07-08-14

2-Deburr if necessary

3.0	QC2	INSPECT PARTS AS THEY COME OFF MACHINE
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HB 07-08-14

Comment: INSPECT PARTS AS THEY COME OFF MACHINE

4.0	QC8	SECOND CHECK
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Comment: SECOND CHECK

En 07/08/14 counted 59

5.0	SMALL FAB 1	SMALL & MEDIUM FAB RESOURCE 1
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Comment: SMALL & MEDIUM FAB RESOURCE 1

Deburr if necessary

SAO07/08/1659

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: LEVER

Job Number: 33887

Part Number: D2160

Job Number:



Seq. #:

Machine Or Operation:

Description :

6.0

BRAKE NC

NC BRAKE



Comment: NC BRAKE

Form as per Dwg D3245

Identify as D2160

JB 07/08/27 (59)

7.0

QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

En 07/08/28 (59) counter

8.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location: _____

EP 07/08/28 (59)

9.0

QC21

FINAL INSPECTION/W/O RELEASE



Comment: FINAL INSPECTION/W/O RELEASE

D 07/08/29 (59)

Job Completion

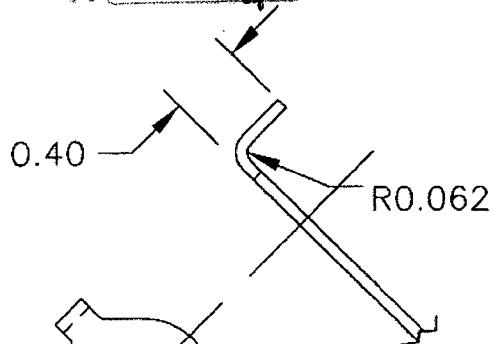


LL 07-08-29

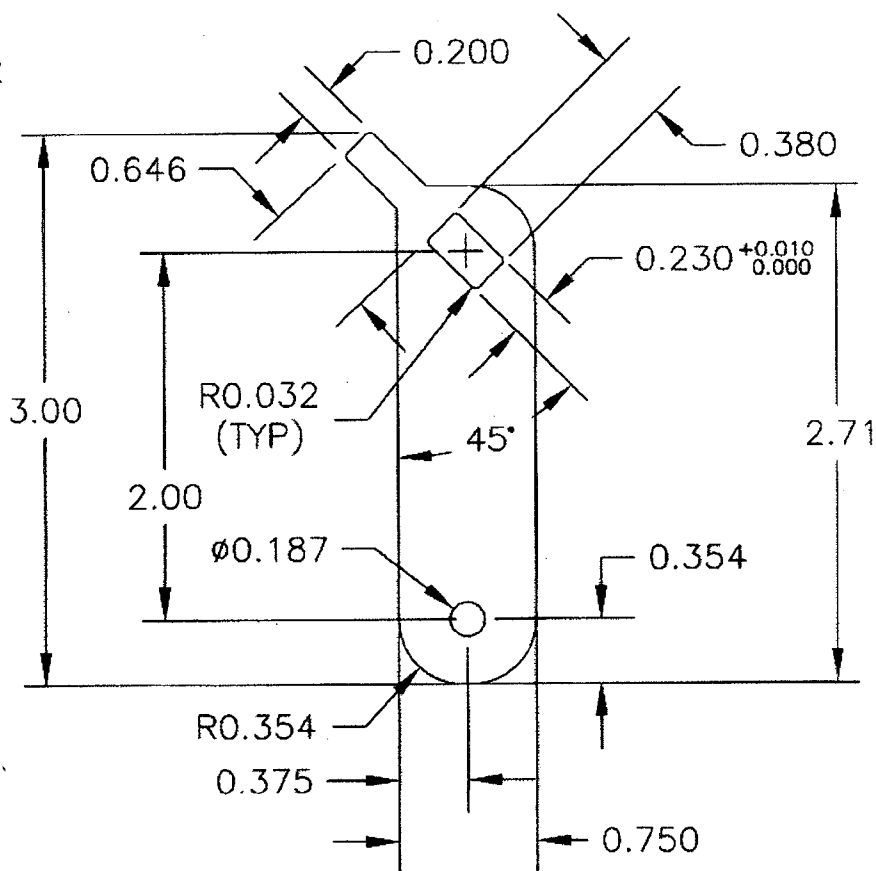


DESIGN BW	DRAWN BY RF	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED [Signature]	APPROVED [Signature]	DRAWING NO. D2160	REV. B SHEET 1 OF 1
DATE 05.01.25		TITLE LEVER	SCALE 1:1
A	93.04.04	NEW ISSUE	
B	05.01.25	ADDED FLAT PATTERN; REMOVED $\phi 0.106$	

RELEASED
05.02.02 [Signature]



BEND DETAIL



FLAT PATTERN

NOTES:

- 1) MATERIAL: AISI 304/316 SS 0.075 (14 GAUGE) THICK (REF. DART SPEC. M304S14GA)
- 2) FINISH: NONE
- 3) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) BREAK ALL SHARP EDGES 0.005 TO 0.015
- 5) ALL DIMENSIONS ARE INCHES

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DART AEROSPACE LTD		Work Order:	33887
Description: LEVER		Part Number:	D2160
Inspection Dwg:	Rev: R		Page 1 of 1

FIRST ARTICLE INSPECTION CHECKLIST

☒ First Article ☐ Prototype

[illegible]

Measured by: RB	Audited by: S	Prototype Approval: N/A
Date: 07-08-14	Date: 07/08/14	Date: N/A

Rev	Date	Change	Revised by	Approved
A		New Issue	KJ/JLM	